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**UNITED STATES
DEPARTMENT OF
AGRICULTURE**

**Agricultural
Marketing
Service**

**Livestock and
Seed Program**

**Washington, DC
20250**

I **INSTITUTIONAL**

M **EAT**

P **URCHASE**

S **PECIFICATIONS**

**FOR SAUSAGE PRODUCTS
SERIES 800
INTERIM**

APPROVED BY USDA

EFFECTIVE DATE - NOVEMBER 1, 1992

INSTITUTIONAL MEAT PURCHASE SPECIFICATIONS

FOR SAUSAGE PRODUCTS

SERIES 800

The United States Department of Agriculture (USDA) through its Agricultural Marketing Service (AMS) develops and maintains the Institutional Meat Purchase Specifications (IMPS) for meat and meat products. The complete IMPS series includes the following ten documents:

General Requirements

<i>Fresh Beef.....</i>	<i>Series 100</i>
<i>Fresh Lamb and Mutton</i>	<i>Series 200</i>
<i>Fresh Veal and Calf.....</i>	<i>Series 300</i>
<i>Fresh Pork.....</i>	<i>Series 400</i>
<i>Cured, Cured & Smoked, & Fully Cooked Pork Products.....</i>	<i>Series 500</i>
<i>Cured, Dried, and Smoked Beef Products</i>	<i>Series 600</i>
<i>Variety Meats and Edible By-Products</i>	<i>Series 700</i>
<i>Sausage Products</i>	<i>Series 800</i>

Quality Assurance Provisions

These specifications are recommended for use in any meat product procuring activity. For assurance that procured items comply with these detailed requirements, the USDA, through its Meat Grading and Certification Branch, provides a voluntary Meat Certification Service. For labeling purposes, only product Certified by the Meat Grading and Certification Branch (MGCB) may contain the letters "IMPS" on the product label. Purchasers desiring this service should contact:

*USDA, AMS, Livestock and Seed Program
Meat Grading and Certification Branch
Stop 0248, Room 2628 S-Bldg
1400 Independence Ave. SW
Washington DC 20250-0248*

For any assistance regarding these documents and for additional copies, please contact:

*USDA, AMS, Livestock and Seed Program
Standardization Branch
Stop 0254, Room 2628 S-Bldg
1400 Independence Ave. SW
Washington, DC 20250-0254*

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Purchaser shall specify IMPS item number, product name, formula, and weight range. The following weight ranges are intended only as guide lines. The purchaser may specify any other weight range, link, or slice count desired.

ITEM NUMBER	PRODUCT NAME	SUGGESTED WEIGHT RANGE
800	FRANKFURTERS	4, 6, 8, 10, 12 LINKS PER POUND
801	BOLOGNA	1 TO 12 POUND UNITS 16, 18, 20, 25 SLICES PER POUND
802	PORK SAUSAGE	1, 2, 3, 4, 5, 6 POUND ROLLS 6, 8, 10, 12, 14, 16, LINKS PER POUND 2, 3, 5, OR 7 POUND BAGS 5, 6, 7, 8, 9, 10, 11, 12 POUND UNITS
802A	PORK SAUSAGE, PATTIES	2.5 or 3 oz. PATTY
802B	PORK SAUSAGE, COOKED	1.5 or 2 oz. PATTY 2, 3, 5, OR 7 POUND BAGS
802C	WHOLE HOG PORK SAUSAGE	6, 8, 10, 12, 14, 16 LINKS PER POUND 1, 2, 3 POUND ROLLS 2, 3, 5, OR 7 POUND BAGS 5, 6, 8, 10 POUND UNITS 1.5 or 2 oz. PATTY 2.5 or 3 oz. PATTY
803	LIVER SAUSAGE	5 TO 8 POUNDS
804	COOKED SALAMI	7 TO 12 POUNDS 16, 18, 20, 25 SLICES PER POUND
805	MINCED LUNCHEON MEAT	5 TO 10 POUNDS 16, 18, 20, 25 SLICES PER POUND
806	LEBANON BOLOGNA	5 TO 10 POUNDS 16, 18, 20, 25 SLICES PER POUND
807	THURINGER	4 TO 8 POUNDS 18, 20, 25, 30 SLICES PER POUND
808	DRY SALAMI	2 TO 5 POUNDS 20, 25, 30 SLICES PER POUND
809	CERVELAT	2 TO 5 POUNDS 20, 25, 30 SLICES PER POUND
810	BREAKFAST SAUSAGE	1, 2, OR 3 POUND ROLLS 8, 10, 12, 16 OR 19-21 LINKS PER POUND 5, 6, 8, OR 10 POUND UNITS
811	SMOKED SAUSAGE	6, 8, 10, 19-21, 48-51 LINKS PER POUND
812	NEW ENGLAND BRAND SAUSAGE	5 TO 10 POUNDS 16, 18, 20, 25 SLICES PER POUND
813	POLISH SAUSAGE	3-5, 11-13 INCHES IN LENGTH
814	MEAT LOAVES	4 TO 8 POUND LOAVES 16, 18, 20, 25 SLICES PER POUND
815	MEAT FOOD PRODUCT LOAVES	4 TO 8 POUND LOAVES 16, 18, 20, 25 SLICES PER POUND
816	KNOCKWURST	5, 6, 7, 8 LINKS PER POUND
817	BREAKFAST SAUSAGE, COOKED	19 TO 21 LINKS PER POUND
818	ITALIAN SAUSAGE	4, 6, 7, 8 LINKS PER POUND 1, 5, 6, 8, 10 POUND UNITS 2, 2.5 or 3 oz. PATTY
819	HAM LINKS	14 TO 15 LINKS PER POUND
820	HEAD CHEESE	4 TO 8 POUNDS 16, 18, 20, 25 SLICES PER POUND
821	PEPPERONI	1 TO 2 POUND STICKS 10 TO 15 SLICES PER OUNCE
822	BRATWURST	4, 6, 7, 8 LINKS PER POUND
822A	BRATWURST PATTY	2.5 OR 3 OZ. PATTY
824	PORK RIB SHAPE PATTY	3.0, 4.0 OR 5.0 OZ. PATTY
825	CANNED LUNCHEON MEAT	30 OUNCE OR 6 POUND CANS
826	SCRAPPLE	1, 5, 10 POUND UNITS

I. ORDERING DATA TO BE SPECIFIED BY THE PURCHASER

Not all of the ordering data options listed below are required to be specified by the purchaser. Most of the products in this series already have "built-in" default options designated in the detailed item descriptions (For example; shape, style, etc.). However, any alternative purchaser options, including those listed below, may be specified by the purchaser in the contract or purchase order as long as those options are clear and concise.

TYPE

- A - Unsliced
- B - Sliced (purchaser must specify a slice count per pound)
- C - Patty
- D - Crumbles
- E - Linked
- F - Bulk

SHAPE

COOKING OPTIONS

- | | |
|-----------------|-------------------------------------|
| A - Rectangular | A - Baked |
| B - Round | B - Cooked |
| | C - Uncooked Fresh (no cure added) |
| STYLE | D - Uncooked Fermented (cure added) |

- A - Artificial casings (inedible)
- B - Hog or sheep casings, linked (natural)
- B1 - Hog or sheep casings, unlinked (natural)
- C - Skinless (mechanically formed)
- D - Collagen casings (edible)
- E - Cloth bags
- F - Bulk

CLASS

- A - Smoked
- B - Unsmoked
- C - Browned in hot oil

NOTE: Unless specifically authorized by the purchaser, use of artificial colors in the manufacture of any sausage item shall not be permitted.

STATE OF REFRIGERATION - See IMPS General Requirements.

- A - CHILLED - 28°F to 40°F (-2.2°C to 5°C)
- B - FROZEN - 0°F or lower (-17.8°C)

PATTY WEIGHT AND THICKNESS TOLERANCES

The purchaser shall specify the portion weight and/or thickness desired. For assistance in specifying a portion weight, see weight range tables. When both weight and thickness are specified, it is recommended that those requirements be limited to items that are mechanically pressed and/or sliced.

PORTION THICKNESS TOLERANCES ^{1/}

Specified Thickness	Thickness Tolerance	Thickness Uniformity
1 inch (25 mm) or less	+/- 3/16 inch (5 mm)	3/16 inch (5 mm)
more than 1 inch (25 mm)	+/- 1/4 inch (6 mm)	1/4 inch (6 mm)

PORTION WEIGHT TOLERANCES ^{1/}

Specified Weight	Weight Tolerance	Thickness Uniformity
Less than 6.0 ounces (170 g)	+/- 1/4 oz (7 g)	3/16 inch (5 mm)
6.0 ounces	+/- 1/2 oz (14 g)	1/4 inch (6 mm) (170 g) or more

^{1/} Thickness measurements not applicable within 1/4 inch (6 mm) of edge. Portion weight and thickness tolerances for cooked patties shall be allowed at the higher value (i.e, +/- 1/2 oz., 1/4 inch) to allow for cooking variances.

USDA CERTIFICATION

IMPS product certification by the USDA is a voluntary service which must be requested by the purchaser in the contract or purchase order.

If USDA Certification is specified by the purchaser, product shall comply with all USDA, AMS, Meat Grading and Certification Branch policies and instructions. ONLY product which is USDA Certified shall display the "**IMPS**" letters on the product label.

Persons wishing more information concerning USDA, Meat Grading and Certification Branch services should contact:

USDA, AMS, Livestock and Seed Program
Meat Grading and Certification Branch
Stop 0248, Room 2628 S-Bldg
1400 Independence Ave. SW
Washington, D.C. 20250-0248

or call (202) 720-1113

II. MATERIAL REQUIREMENTS

To be in full compliance with this specification, all product offered by the manufacturer must comply with the following material requirements and the individual item descriptions. For USDA Certification, **unless otherwise authorized**, all product shall be evaluated in the fresh state in accordance with the IMPS QUALITY ASSURANCE PROVISIONS.

Presence of one or more of any of the following conditions shall cause rejection of the involved production lot.

- o Product which exhibits any evidence of being moldy (note exception to dry and semi-dry sausage), stale, slimy, oily, sticky, sour, or discolored.
- o Product not of the meat formula, color, style, class, or state of refrigeration as specified by the purchaser.
- o Nonformula ingredients not as specified.
- o Presence of foreign flavor (for example; moldy, sour, or stale).
- o Presence of foreign odor (for example; acidic, putrid, stale, sour, or rancid).
- o Presence of foreign material. Determination of wholesomeness and acceptability of meat with respect to the presence of foreign material (for example; glass, dirt, insect parts, hair, wood, or metal) shall be made by a Meat and Poultry Inspection Operations (MPIO) employee.

Product items must contain only those kinds of meats specified by the purchaser and shall reflect the appropriate style, formula, shape, weight range, and state of refrigeration (as applicable).

Amounts and kinds of all ingredients must be within the tolerances permitted by the applicable USDA, MPIO Inspection regulations.

As applicable, curing, cooking, smoking and flavoring of product shall be typical of the particular kind of product being produced. The color and aroma of the finished sausage item shall also be characteristic of the product being produced, for example, there shall be no evidence of greening, streaking, or other discoloration (a slightly two toned or iridescent color is permissible). Product shall be practically free from bone, cartilage, string, air holes, pockets of moisture, fat caps, rendered fat, gelatin caps, and shall be totally free from odor or flavor foreign to the product including, acidic odor, rancidity, mold (dry and semi-dry sausage items may not have more than a very slight amount of "dry" surface mold present), or any other deterioration or damage. In addition, sliced product shall be free of all casing material. Product shall show no evidence of having been frozen and defrosted, or otherwise mishandled in any way.

SMOKED PRODUCTS

Smoked products shall have an acceptable flavor and aroma and a fairly bright, uniform smoked color, and be practically free of extraneous material, including encrusted salt and smokehouse residue (except the natural smoke color). The product shall be fairly dry on the exterior of the casing, but not scorched. Except for loaf items, smoke flavoring or artificial smoke flavoring is permissible in lieu of smoking unless otherwise specified by the purchaser.

SPICES AND SEASONINGS

When a spice, or seasoning is specifically required within the individual item description, that particular seasoning or ingredient shall be **individually depicted** on the manufacturers label of ingredients.

INGREDIENT/FORMULA CERTIFICATION

Ingredient and meat content verification of sausage products in this specification, except as otherwise stated, shall be the responsibility of an FSIS, MPIO employee. However, the purchaser and/or AMS Agent reserve the right at any time to verify the ingredients and/or meat species included in the sausage item(s) using approved testing methods.

IMPORTANT NOTE: The product name of combination red meat and poultry formulated sausage items, must be labeled as follows:

FORMULA LABELING REQUIREMENT

P	-	Beef and Turkey IMPS NAME (Frankfurter, etc.)
P1	-	Beef and Chicken IMPS NAME (Bologna, etc.)
P2	-	Pork and Turkey IMPS NAME (Salami, etc.)
P3	-	Pork and Chicken IMPS NAME (Frankfurter, etc.)

EXAMPLE - If the purchaser wishes to purchase an IMPS 802 Bologna formula P2, the product would be labeled:

IMPS No. 802, Pork and Turkey Bologna

LOWER FAT FORMULATIONS

In the interest of providing a lower fat formulation option for the institutional purchaser, **Formula L** in this 800 Series document, is listed for several different sausage items. If the purchaser desires to purchase a particular sausage item with a lower fat content, the following procedures shall be followed:

- (1) Specify the individual IMPS Item to be produced which has a Formula L option included. (EXAMPLE: IMPS Item 800)
- (2) Specify Formula L on the contract or purchase order.
- (3) Specify one additional meat or meat and poultry formula from those listed in each item description which is to be manufactured with a lower fat content. (EXAMPLE: The purchaser would select Formula L initially and then select the desired meat or meat and poultry ingredient such as formula A or B or C, etc., from those listed with each item). **If the purchaser should fail to specify the meat or meat and poultry component to be used in Formula L, the meat ingredient shall be all beef.**
- (4) Total fat content of the finished sausage item being produced for Formula L shall not exceed 20.00 percent regardless of the meat or meat and poultry component specified by the purchaser. The purchaser may specify a maximum fat limitation lower than 20.00 percent, and may also specify discount ranges.
- (5) Any additional ingredients used in **Formula L** (soy, carrageenan, etc.) may be specified or disallowed by the purchaser, and shall be formulated and identified in the ingredients statement in accordance with all FSIS regulations. For IMPS, regardless of the sausage item being produced, the maximum amount of added ingredients shall not exceed **30.00 percent** of the formula.
- (6) Product produced as Formula L must be labeled as follows:

IMPS ITEM NAME, X% ADDED INGREDIENTS

(X= no more than 30%)

EXAMPLE: **Frankfurter, 25% Added Ingredients** (see IMPS General Requirements for additional container marking criteria)

- (7) The fat content shall be determined at an FSIS approved and certified laboratory designated by the vendor. The vendor shall be totally responsible for supplying official documentation of the fat analysis results of each production lot to the purchaser. **Alternatively, if the purchaser wishes the analytical content to be certified by USDA, AMS, the purchaser MUST specify that option in the contract or purchase order.** When the purchaser requests fat content to be certified by the USDA, an average sample shall be drawn by the AMS agent which shall be sent to the USDA, AMS laboratory for fat analysis.

NOTE: Detailed sampling procedures and defect applications are specified in the **IMPS QUALITY ASSURANCE PROVISIONS**.

III. DETAILED ITEM DESCRIPTIONS

Item No. 800 - Frankfurters

Frankfurters are a smoked, cooked, linked, skinless sausage. Frankfurters shall have a fine smooth exterior surface which is free of splits, cracks, casing material, and shall be uniform in length and diameter. Links shall be 5 to 6 inches (12.7 to 15.2 cm) in length.

The red meat or red meat and poultry components shall be very finely comminuted. The interior cut surface shall be smooth, fine-textured, light to moderately dark pink in background color, and finely mottled with evenly distributed light to dark red flecks.

ORDERING DATA: OPTIONS AND FORMULA DESIRED SHALL BE SPECIFIED BY THE PURCHASER

Formula (major ingredients only)

- A - Beef and pork (in any combination)
- A1 - Formula A plus nonfat dry milk and/or calcium reduced dried skim milk
- B - Beef, pork (beef is predominant)
- B1 - Formula B plus nonfat dry milk and/or calcium reduced dried skim milk
- C - Pork, beef (pork is predominant)
- C1 - Formula C plus nonfat dry milk and/or calcium reduced dried skim milk
- D - Beef
- L - Formula (A,B,C, etc., as specified), lower fat formulation.¹
- P - Beef and Turkey (beef is predominant)
- P1 - Beef and Chicken (beef is predominant)
- P2 - Pork and Turkey (pork is predominant)
- P3 - Pork and Chicken (pork is predominant)

¹ See Lower Fat Formulations Section, Pg. 7, for specific requirements.

Item No. 801 - Bologna

Bologna is a smoked, cooked sausage. The red meat or red meat and poultry components shall be very finely comminuted and stuffed into artificial or natural casings. The interior cut surface is smooth, fine-textured, light to moderately dark pink in background color, and finely mottled with evenly distributed light to dark red flecks. Sticks shall have a uniform diameter measuring from 4 to 5 inches (10.2 to 12.7 cm). The 1 to 1.5 pound (0.5 to 0.7 kg) size shall be ring style.

ORDERING DATA: OPTIONS AND FORMULA DESIRED SHALL BE SPECIFIED BY THE PURCHASER

Formula (major ingredients only)

- A - Beef and Pork (in any combination)
- A1 - Formula A plus nonfat dry milk and/or calcium reduced dried skim milk
- B - Beef, pork (beef is predominant)
- B1 - Formula B plus nonfat dry milk and/or calcium reduced dried skim milk
- C - Pork, beef (pork is predominant)
- C1 - Formula C plus nonfat dry milk and/or calcium reduced dried skim milk
- D - Beef
- L - Formula (A,B,C, etc., as specified), lower fat formulation.¹
- P - Beef and Turkey (beef is predominant)
- P1 - Beef and Chicken (beef is predominant)
- P2 - Pork and Turkey (pork is predominant)
- P3 - Pork and Chicken (pork is predominant)

Item No. 802 - Pork Sausage

Pork sausage is a fresh, all pork product, grayish-pink to grayish light red in color. The meat is chopped or ground to a moderately coarse texture, and thoroughly blended and mixed with salt and spices. Pork sausage may be packed in bulk, formed mechanically, or stuffed in artificial or natural casings. The links, rolls, and bags shall be moderately uniform in length and diameter. For product in unlinked hog or collagen casings, no more than one piece shall be less than 12 inches (30.5 cm) in length in a primary container.

Style

- A - Artificial casings (inedible)
- B - Hog or sheep casings, linked (natural)
- B1 - Hog or sheep casings, unlinked (natural)
- C - Skinless (mechanically formed)
- D - Collagen casings (edible)
- E - Cloth bags
- F - Bulk

¹ See Lower Fat Formulations Section, Pg. 7, for specific requirements.

Item No. 802A - Pork Sausage Patties

This item is as described for Item 802 except that the fresh pork sausage shall be ground or chopped and unless otherwise specified by the purchaser, mechanically formed into approximately round 4.0 inch (10.2 cm) diameter patties. The finished product shall be uniform in weight, thickness and diameter.

Patty size options (diameter)

- A. 2.0 inch
- B. 2.5 inch
- C. 3.0 inch
- D. 3.5 inch
- F. 4.0 inch

Item No. 802B - Pork Sausage, Cooked

This item is as described for Item 802 or 802A except that the pork sausage shall be fully cooked. The cooked pork sausage may be produced either as a patty or crumbled for use as a pizza topping, which ever is specified by the purchaser. If this item is produced as a cooked patty, specific diameter size requirements specified for Item 802A shall not apply. However, the finished cooked patties shall be required to be uniform in thickness and diameter. **NOTE:** The particular type selected by the purchaser shall follow the IMPS name, EXAMPLE; **Pork Sausage, Cooked, Crumbles**

Type

- C - Patties
- D - Crumbles

Item No. 802C - Whole Hog Pork Sausage

This item is as described for Item 802, 802A or 802B except that it shall contain all of the primal parts of the hog in natural proportions (controlled by FSIS, MPIO). Meat by-products (heart, tongue, etc.), which otherwise must be declared in the ingredient statement, shall not be authorized in this item. Unless otherwise specified by the purchaser, the product (except for crumbles which shall be cooked) shall be uncooked and bulk packed into 10 pound (4.5 kg) units. **NOTE:** The particular type and cooking option (when applicable) selected by the purchaser shall follow the IMPS name, EXAMPLE; **Whole Hog Pork Sausage, Links, Cooked**

Type**Cooking Option**

- | | |
|--------------|-------------|
| C - Patties | B. Cooked |
| D - Crumbles | C. Uncooked |
| E - Links | |
| F - Bulk | |

Item No. 803 - Liver Sausage (Braunschweiger)

Liver sausage is a cooked sausage with a smoked characteristic (a smoked characteristic may be imparted by smoking, by adding smoked meats to the formula, or a combination of both). The meat components consist of pork with smoked jowls and/or bacon ends included in some formulas. These are combined with pork livers, very finely comminuted and stuffed in artificial or natural casings. Onion shall be included as a seasoning. Unless otherwise specified by the purchaser, sticks shall have a uniform diameter measuring from 2 to 3 inches (5.1 to 7.6 cm) and shall weigh from 5 to 8 pounds (2.3 to 3.6 kg). The interior cut surface is smooth, fine-textured and light reddish-brown in color.

ORDERING DATA: OPTIONS AND FORMULA DESIRED SHALL BE SPECIFIED BY THE PURCHASER

Formula (major ingredients only)

- A - Pork livers, pork
- A1 - Formula A plus nonfat dry milk and/or calcium reduced dried skim milk
- B - Pork livers, pork with smoked jowls and/or bacon ends and pieces
- B1 - Formula B plus nonfat dry milk and/or calcium reduced dried skim milk

Item No. 804 - Salami, Cooked

Cooked salami is a smoked, cooked sausage. The meat components consist of moderately coarse-cut pork and finely comminuted beef with finely comminuted beef heart meat included in some formulas. Alternatively, a moderately coarse-cut beef or red meat and poultry formulation may be specified. Seasonings, unless otherwise specified, shall include garlic and whole black peppercorns (at least a portion of a peppercorn shall be in evidence on either sliced surface). Salami is stuffed in artificial casings and has a uniform diameter measuring from 3.5 to 4.5 inches (8.9 to 11.4 cm) (unless otherwise specified by the purchaser). Sticks shall weigh from 7 to 12 pounds (3.2 to 5.4 kg) and shall be moderately uniform in length. The interior cut surface is moderately coarse in texture and light to dark reddish-brown in color.

ORDERING DATA: OPTIONS AND FORMULA DESIRED SHALL BE SPECIFIED BY THE PURCHASER

Formula (major ingredients only)

- A - Pork and beef
- A1 - Pork, Beef
- A2 - Beef, Pork
- B - Pork and beef, beef heart meat
- C - Pork and beef, with non fat dry milk and/or calcium reduced dried skim milk added
- D - Beef
- L - Formula (A,B,C, etc., as specified), lower fat formulation¹
- P - Beef and Turkey (beef is predominant)
- P1 - Beef and Chicken (beef is predominant)
- P2 - Pork and Turkey (pork is predominant)
- P3 - Pork and Chicken (pork is predominant)

¹ See Lower Fat Formulations Section, Pg 7, for specific requirements.

Item No. 805 - Minced Luncheon Meat

Minced luncheon meat is a smoked, cooked sausage. The meat components consist of moderately coarse-cut pork and finely comminuted beef with pork heart meat included in some formulas. The product is stuffed into artificial casings. Stuffed round casings shall measure from 3.5 to 4.5 inches (8.9 to 11.4 cm) in diameter (unless otherwise specified by the purchaser). When the stuffed casings are formed into rectangular shapes by wire or metal molds, they shall measure from 3 to 4 inches (7.6 to 10.2 cm) in width and depth (unless otherwise specified by the purchaser). Product shall weigh from 5 to 10 pounds (2.3 to 4.5 kg). The interior cut surface is moderately fine-textured and light pink in color. The finished product shall be uniform in diameter.

ORDERING DATA: OPTIONS AND FORMULA DESIRED SHALL BE SPECIFIED BY THE PURCHASER

Formula (major ingredients only)

- A - Pork, beef (pork is predominant)
- A1 - Formula A plus nonfat dry milk and/or calcium reduced dried skim milk
- B - Pork, beef, pork heart meat
- B1 - Formula B plus nonfat dry milk and/or calcium reduced dried skim milk

Item No. 806 - Lebanon Bologna

Lebanon bologna is a "semi-dry", smoked, uncooked, all beef sausage. The meat component is finely comminuted beef stuffed in artificial casings. Sticks are from 3.5 to 4.5 inches (8.9 to 11.4 cm) in diameter (unless otherwise specified by the purchaser) and shall weigh from 5 to 10 pounds (2.3 to 4.5 kg). The product has a characteristically sharp (fermented) flavor. The interior cut surface is fine-textured and exhibits a uniform dark reddish-brown background color with fine particles evenly distributed. A very slight amount of dry surface mold is natural on this product and may be present on this item. No binders or extenders are permitted. The finished product shall be uniform in diameter.

Item No. 807 - Thuringer

Thuringer is a "semi-dry", smoked, uncooked sausage. The meat components are moderately coarse-cut beef, beef and pork or moderately coarse-cut beef with beef heart meat. Thuringer is stuffed in artificial casings and measures from 2.5 to 3.5 inches (6.4 to 8.9 cm) in diameter (unless otherwise specified by the purchaser). Sticks shall weigh from 4 to 8 pounds (1.8 to 3.6 kg). The product has a characteristically sharp (fermented) flavor. The interior cut surface is moderately coarse-textured and has a uniform dark reddish-brown color. A very slight amount of dry surface mold is natural on this product and may be present on this item. No binders or extenders are permitted. The finished product shall be uniform in diameter.

ORDERING DATA: OPTIONS AND FORMULA DESIRED SHALL BE SPECIFIED BY THE PURCHASER

Formula (major ingredients only)

- A - Beef
- B - Beef, beef heart meat
- C - Beef and pork
- D - Beef and pork, beef heart meat
- E - Beef, pork
- F - Beef, pork, beef heart meat

Item No. 808 - Dry Salami

Dry salami is a smoked, uncooked, "dry" sausage. The meat components consist of moderately coarse-cut beef with moderately coarse-cut pork and/or beef heart meat included in some formulas. The product seasoning includes garlic. Dry salami is stuffed in artificial or natural casings, measuring from 2 to 3 inches (5.1 to 7.6 cm) in diameter (unless otherwise specified by the purchaser), and is processed to produce a firm, hard product. Sticks shall weigh from 2 to 5 pounds (0.9 to 2.3 kg). The interior cut surface is firm, moderately coarse-textured with a uniform distribution of white fat particles throughout a medium to dark reddish-brown background color. A very slight amount of dry surface mold is natural on this product and may be present on this item. No binders or extenders are permitted. The finished product shall be uniform in diameter.

ORDERING DATA: OPTIONS AND FORMULA DESIRED SHALL BE SPECIFIED BY THE PURCHASER

Formula (major ingredients only)

- A - Beef
- B - Beef, beef heart meat
- C - Beef and pork (in any combination)
- D - Beef and pork, beef heart meat
- E - Beef, pork (beef is predominant)
- F - Beef, pork, beef heart meat
- G - Pork

Item No. 809 - Cervelat

Cervelat is a smoked, cooked, "semi-dry," or "dry" sausage. The meat components consist of finely comminuted beef and pork stuffed in artificial or natural casings and is processed to produce a firm product. Sticks measure from 1.5 to 2 inches (3.8 to 5.1 cm) in diameter (unless otherwise specified by the purchaser) and shall weigh from 2 to 5 pounds (0.9 to 2.3 kg). The interior cut surface is fine-textured and exhibits a uniform medium to dark reddish-brown color. A very slight amount of dry surface mold is natural on this product and may be present on this item. No binders or extenders are permitted. The finished product shall be uniform in diameter.

ORDERING DATA: OPTIONS AND FORMULA DESIRED SHALL BE SPECIFIED BY THE PURCHASER

Formula (major ingredients only)

- A - Beef, pork (beef is predominant)
- B - Pork, beef (pork is predominant)

Item No. 810 - Breakfast Sausage

Breakfast sausage is a fresh product. The meat components consist of predominately pork with smaller amounts of beef and/or veal. Alternatively, an all beef or red meat and poultry formulation may be specified. The meat is chopped or ground to a moderately coarse texture. Breakfast sausage may be packed in bulk or stuffed in a collagen or hog casings. The links and rolls are moderately uniform in length and diameter. For product in unlinked hog or collagen casings, no more than one piece shall be less than 12 inches (30.5 cm) in length in a primary container.

ORDERING DATA: OPTIONS AND FORMULA DESIRED SHALL BE SPECIFIED BY THE PURCHASER

Formula (major ingredients only)

Cooking Option

- | | |
|---|--------------|
| A - Pork, beef (pork is predominant) | B - Cooked |
| B - Beef | C - Uncooked |
| C - Pork, beef, veal | |
| D - Pork, veal | |
| L - Formula (A,B,C, etc., as specified), lower fat formulation ¹ | |
| P - Beef and Turkey (beef is predominant) | |
| P1- Beef and Chicken (beef is predominant) | |
| P2- Pork and Turkey (pork is predominant) | |
| P3- Pork and Chicken (pork is predominant) | |

Item No. 811 - Smoked - Sausage

Smoked sausage is a smoked, cooked, linked sausage. The meat components consist of all pork or pork and beef with beef tripe, beef and pork heart meat, and beef and pork tongue meat included in some formulas. The meat is chopped or ground to a moderately coarse texture. Smoked sausages are either skinless or stuffed in hog or collagen casings and are moderately uniform in length and diameter. The interior cut surface is moderately coarse in texture (formulas D and D1 may be moderately fine-textured).

ORDERING DATA: OPTIONS AND FORMULA DESIRED SHALL BE SPECIFIED BY THE PURCHASER

¹ See Lower Fat Formulation Section, Pg 7, for specific requirements.

Formula (major ingredients only)

- A - Pork
- B - Pork, beef (pork is predominant)
- B1 - Formula B plus nonfat dry milk and/or calcium reduced dried skim milk
- C - Beef, pork (beef is predominant)
- C1 - Formula C plus nonfat dry milk and/or calcium reduced dried skim milk
- D - Beef and pork, plus any one or any combination of beef tripe, beef heart meat, pork heart meat, beef tongue meat, and pork tongue meat
- D1 - Formula D plus nonfat dry milk and/or calcium reduced dried skim milk
- E - Beef

Item No. 812 - New England Brand Sausage

New England Brand sausage is a smoked, cooked sausage. The meat components consist predominately of pork chunks with a small amount of finely comminuted beef. The product is stuffed in artificial or natural casings with a uniform diameter of between 3.5 to 4.5 inches (8.9 to 11.4 cm) (unless otherwise specified by the purchaser). Individual sausages shall weigh from 5 to 10 pounds (2.3 to 4.5 kg). The texture of the interior cut surface is variable, 70-80 percent of the area consists of pork chunks, and the remaining portion is fine-textured.

Item No. 813 - Polish Sausage

Polish sausage is a smoked, cooked, linked sausage. The meat components consist of moderately coarse-cut pork or moderately coarse-cut pork with finely comminuted beef, or beef and veal. Alternatively, a moderately coarse-cut beef or red meat and poultry formulation may be specified. Seasonings shall include garlic. The product is stuffed in hog casings or equivalent diameter collagen casings (specified by the purchaser). The interior cut surface is moderately coarse in texture with a uniform distribution of light colored particles throughout a medium to dark reddish-brown background color. Links shall be moderately uniform in length and diameter. Links shall be 3 to 5 inches (7.6 to 12.7 cm) long (unless otherwise specified by the purchaser).

ORDERING DATA: OPTIONS AND FORMULA DESIRED SHALL BE SPECIFIED BY THE PURCHASER

Formula (major ingredients only)

- A - Pork, Beef, (pork is predominant)
- B - Pork, beef, veal (pork is predominant)
- C - Pork, beef (pork is predominant) with non-fat dried milk added
- D - Beef
- E - Pork
- P - Beef and Turkey (beef is predominant)

- P1- Beef and Chicken (beef is predominant)
- P2- Pork and Turkey (pork is predominant)
- P3- Pork and Chicken (pork is predominant)

Item No. 814 - Meat Loaves

Meat loaves are baked (dry heat) or cooked (moist heat) products (as specified). The meat components are finely comminuted and may be rectangular or rounded in shape. Meat loaves shall weigh from 4 to 8 pounds (1.8 to 3.6 kg). The exterior surface may be smoked, unsmoked, or browned in hot oil. The interior cut surface is smooth, fine-textured, light pink in background color, and finely mottled with evenly distributed light to dark red flecks. The individual loaves are encased or wrapped in grease and moisture resistant paper or plastic film. The finished product shall be uniform in diameter.

ORDERING DATA: OPTIONS AND FORMULA DESIRED SHALL BE SPECIFIED BY THE PURCHASER

Formula (major ingredients only)

- A - Pork, veal (pork is predominant)
- A1 - Formula A plus nonfat dry milk and/or calcium reduced dried skim milk
- B - Pork, beef (pork is predominant)
- B1 - Formula B plus nonfat dry milk and/or calcium reduced dried skim milk
- C - Pork, beef, veal
- C1 - Formula C plus nonfat dry milk and/or calcium reduced dried skim milk
- D - Pork
- D1 - Formula D plus nonfat dry milk and/or calcium reduced dried skim milk
- E - Veal
- E1 - Formula E plus nonfat dry milk and/or calcium reduced dried skim milk
- F - Beef
- F1 - Formula F plus nonfat dry milk and/or calcium reduced dried skim milk
- G - Ham
- G1 - Formula G plus nonfat dry milk and/or calcium reduced dried skim milk

Class

Cooking Option

- | | |
|------------------------|-------------------------|
| A - Smoked | A - Baked (dry heat) |
| B - Unsmoked | B - Cooked (moist heat) |
| C - Browned in hot oil | |

Shape

- A - Rectangular
- B - Rounded

Item No. 815 - Meat Food Product Loaves

Meat food product loaves are baked (dry heat) or cooked (moist heat) products. Beef, pork and veal may be used singularly or in any combination. Other ingredients such as meat by-products, pickles, pimentos, cheese, nuts, etc., are added as applicable except that lungs, spleens, tripe, udders, blood, skin, cracklings, brains, lips, ears, snouts, kidneys, tongue trimmings, and meat and meat by-products from lamb, yearling mutton, mutton, and goats shall not be used in preparing the loaf. Nonfat dry milk and/or calcium reduced dried skim milk may be added. Individual loaves shall weigh from 4 to 8 pounds (1.8 to 3.6 kg). The exterior surface may be smoked, unsmoked, or browned in hot oil. The other ingredients, pimento, pickle's, olive's, cheese, pepper, etc., (actual ingredients are to be identified and controlled by FSIS, MPIO) as applicable, shall be of a quantity and size large enough to be easily distinguished from the cut surface and shall be reasonably well distributed throughout the item. Pimento juice, pickle juice, olive juice, etc., shall not be substitutable for the fruit itself. The individual loaves shall be encased or wrapped in grease and moisture resistant paper or plastic film. The finished product shall be uniform in diameter.

Meat food product loaves must be specified by name (for example: pickle loaf, ham and cheese loaf, etc.) Any meat food product loaf not listed below may be ordered. However, if the name is inadequate to appropriately identify the product, the purchaser may be requested to furnish additional information to establish a definite basis for identification.

ORDERING DATA: OPTIONS AND FORMULA DESIRED SHALL BE SPECIFIED BY THE PURCHASER

Formula (major condiment ingredients)

- A. Pimento Loaf (sweet red peppers are not substitutable)
- B. Pickle and Pimento Loaf
- C. Pickle Loaf
- D. Olive Loaf (use of stuffed olives is not acceptable)
- E. Pepper Loaf (contains cracked black pepper)
- F. Cheese Loaf
- G. Macaroni and Cheese Loaf
- H. Liver Loaf
- I. Pickle and Pimiento Loaf (sweet red peppers)

Class	Shape	Cooking Option
A - Smoked (dry heat)	A - Rectangular	A - Baked
B - Unsmoked (moist heat)	B - Round	B - Cooked
C - Browned in hot oil		

Item No. 816 - Knockwurst

Knockwurst is a smoked, cooked, linked sausage. Knockwurst may be either skinless or stuffed into hog or collagen casings (as specified by the purchaser). The links shall be moderately uniform in length and diameter and shall be 4 to 5 inches (10.2 to 12.7 cm) in length. The meat components consist of very finely comminuted beef or beef and pork. Alternatively, a red meat and poultry formulation may be specified. The interior cut surface is smooth, fine-textured, and light to moderately dark pink in color (not artificially colored).

ORDERING DATA: OPTIONS AND FORMULA DESIRED SHALL BE SPECIFIED BY THE PURCHASER

Formula (major ingredients only)

- A - Beef
- A1 - Formula A plus nonfat dry milk and/or calcium reduced dried skim milk
- B - Beef and pork
- B1 - Formula B plus nonfat dry milk and/or calcium reduced dried skim milk
- C - Beef, pork (beef is predominant)
- C1 - Formula C plus nonfat dry milk and/or calcium reduced dried skim milk
- L - Formula (A,B,C, etc., as specified), lower fat formulation¹
- P - Beef and Turkey (beef is predominant)
- P1 - Beef and Chicken (beef is predominant)
- P2 - Pork and Turkey (pork is predominant)
- P3 - Pork and Chicken (pork is predominant)

Item No. 817 - Breakfast Sausage, Cooked

Breakfast sausage, is a cooked, linked sausage. The meat components consist of moderately coarse-cut pork and/or beef. Alternatively, a moderately coarse-cut red meat and poultry formulation may be specified. The links shall either be skinless or stuffed into collagen casings (as specified by the purchaser) and shall be uniform in length and diameter. The interior cut surface is moderately coarse in texture.

ORDERING DATA: OPTIONS AND FORMULA DESIRED SHALL BE SPECIFIED BY THE PURCHASER

Formula (major ingredients only)

- A - Pork, beef (pork is predominant)
- B - Pork and beef
- C - Pork
- D - Beef
- L - Formula (A,B,C, etc., as specified), lower fat formulation¹
- P - Beef and Turkey (beef is predominant)
- P1 - Beef and Chicken (beef is predominant)
- P2 - Pork and Turkey (pork is predominant)
- P3 - Pork and Chicken (pork is predominant)

¹ See Lower Fat Formulation Sections, Pg 7, for specific requirements

Item No. 818 - Italian Sausage

Italian sausage is a fresh, uncooked, linked product (unless otherwise specified). The meat components shall be chopped or ground to a moderately coarse texture. The sausage itself (or interior cut surface of links) is moderately coarse in texture with a uniform color ranging from medium to dark reddish-brown with evenly distributed fat particles. Unless otherwise specified by the purchaser, the sausage shall be flavoring style B. The links (unless otherwise specified) shall be in a natural hog or collagen casing 5 to 6 inches (12.7 to 15.2 cm) in length. Links shall be moderately uniform in length and diameter. Patties shall be uniform in diameter. **NOTE:** The particular type and cooking option (when applicable) selected by the purchaser shall follow the IMPS name, EXAMPLE; **Italian Sausage, Crumbles, Cooked**

ORDERING DATA: OPTIONS AND FORMULA DESIRED SHALL BE SPECIFIED BY THE PURCHASER

Formula (major ingredients only)

- A - Beef
- A1 - Formula A plus nonfat dry milk and/or calcium reduced dried skim milk
- B - Beef and pork
- B1 - Formula B plus nonfat dry milk and/or calcium reduced dried skim milk
- C - Beef, pork (beef is predominant)
- C1 - Formula C plus nonfat dry milk and/or calcium reduced dried skim milk
- D - Pork
- P - Beef and Turkey (beef is predominant)
- P1 - Beef and Chicken (beef is predominant)
- P2 - Pork and Turkey (pork is predominant)
- P3 - Pork and Chicken (pork is predominant)

FLAVORING A - Hot (Shall contain crushed or ground pepper & ground coriander in the formula)

B - Sweet (**NO** crushed or ground red pepper or ground coriander in the formula)

Type		Cooking Option
C - Patties	E - Links	B. Cooked
D - Crumbles	F - Bulk	C. Uncooked

Item No. 819 - Ham Links

Ham links are a smoked, fully-cooked, linked, skinless sausage. The meat components consist of chopped or ground ham or ham trimmings exhibiting a moderately fine-textured internal appearance. The interior cut surface is light pink to light red in color with darker pinkish-red particles distributed throughout. Links shall have a fine smooth exterior surface 4 to 5 inches (10.2 to 12.7 cm) in length. The links shall be uniform in length and diameter.

Item No. 820 - Head Cheese

Head cheese is a cooked product. The meat components may consist of all pork head meats or predominately pork head meats with pork, cured pork and/or other pork by-products included, except that ears, livers and spleens are prohibited. The meat is

coarse-cut to fine-cut. Onion shall be included as a seasoning. Head cheese may have gelatin added. The finished product is stuffed in artificial or natural casings and shall weigh from 4 to 8 pounds (1.8 to 3.6 kg) with a uniform diameter. The interior cut surface is resilient, and very coarse-textured with an even distribution of ingredients.

Item No. 821 - Pepperoni

Pepperoni is a moderately coarse-textured "dry" sausage prepared from pork or pork and beef. The interior cut surface is moderately coarse in texture with a uniform color ranging from medium to dark brownish-red. Unless otherwise specified by the purchaser, the sticks shall measure 1.5 inches (2.5 cm) to 2 inches (5.1 cm) in diameter. A very slight amount of dry surface mold is natural on this product and may be present on this item. Pepperoni is processed to produce a firm, hard product, moderately uniform in length and diameter. Pepperoni shall contain no extenders or binders.

ORDERING DATA: OPTIONS AND FORMULA DESIRED SHALL BE SPECIFIED BY THE PURCHASER

Formula (major ingredients only)

- A - Pork
- B - Pork and beef

Item No. 822 - Bratwurst

Bratwurst may either be a cooked or an uncooked (as specified) link sausage. The meat components may range from fine to slightly coarse comminuted pork, veal, pork and beef, or veal and pork. Alternatively, a fine to slightly coarse comminuted red meat and poultry formulation may be specified. The interior cut surface is fairly smooth, and light to pale pink in color. The interior cut surface of cooked bratwurst is a light to pale gray color. Spices shall include garlic. Bratwurst is either skinless or stuffed into natural or collagen casings (as specified by the purchaser). The links shall be uniform in length and diameter. Unless otherwise specified by the purchaser, the links shall be uncooked and 4.5 to 5.5 inches (11.4 to 14.0 cm) in length.

ORDERING DATA: OPTIONS AND FORMULA DESIRED SHALL BE SPECIFIED BY THE PURCHASER

Formula (major ingredients only)

- A - Pork
- A1 - Pork, with non fat dry milk added
- B - Pork, beef (pork is predominant)
- B1 - Pork, beef (pork is predominant) with non fat dry milk added
- C - Veal and Pork (veal is predominant)
- C1 - Veal and Pork (veal is predominant) with non fat dry milk added
- D - Veal
- E - Beef
- L - Formula (A,B,C, etc., as specified), lower fat formulation¹

¹ See Lower Fat Formulations Section, Pg 7, for specific requirements.

- P - Beef and Turkey (beef is predominant)
- P1 - Beef and Chicken (beef is predominant)
- P2 - Pork and Turkey (pork is predominant)
- P3 - Pork and Chicken (pork is predominant)

Cooking Option

- B - Cooked
- C - Uncooked

Item No. 822A - Bratwurst Patty

This item is as described for Item 822 except that the bratwurst, instead of being formed into a link, shall be mechanically formed into round 4.0 inch (10.2 cm) (unless otherwise specified) diameter patties. If this item is produced as a cooked patty, diameter size requirements specified shall not apply. The finished product shall be uniform in weight, thickness and diameter.

Patty size options (diameter)

- A. 2.0 inch
- B. 2.5 inch
- C. 3.0 inch
- D. 3.5 inch
- F. 4.0 inch

Cooking Option

- B - Cooked
- C - Uncooked

ORDERING DATA: OPTIONS AND FORMULA DESIRED SHALL BE SPECIFIED BY THE PURCHASER

Formula (major ingredients only)

- A - Pork
- A1 - Pork, with non fat dry milk added
- B - Pork, beef (pork is predominant)
- B1 - Pork, beef (pork is predominant) with non fat dry milk added
- C - Veal and Pork (veal is predominant)
- C1 - Veal and Pork (veal is predominant) with non fat dry milk added
- D - Veal
- E - Beef
- L - Formula (A,B,C, etc., as specified), lower fat formulation¹
- P - Beef and Turkey (beef is predominant)
- P1 - Beef and Chicken (beef is predominant)

- P2 - Pork and Turkey (pork is predominant)
- P3 - Pork and Chicken (pork is predominant)

Item No. 824 - Pork Rib Shape Patty

Fresh, uncured, boneless pork shall be ground one (1) time only through a 0.25 inch (6.35 mm) plate, mixed with the appropriate seasonings (if specified) and mechanically formed to give the appearance, consistency and texture of a natural rib slab with rib protrusions. Alternatively, the item may be produced using any FSIS approved and labeled restructuring method which will yield an acceptable end item that exhibits the appearance, consistency and texture of a natural rib slab. The texture of this item shall be moderately coarse and shall be light pink to light red in color. If desired, the purchaser may further specify the shape dimensions of this item. The fat content shall not exceed 25.00 percent which shall be determined at a FSIS approved and certified laboratory designated by the vendor, who shall supply official documentation of the fat analysis results of each production lot to the purchaser.

Alternatively, if the purchaser wishes the analytical content to be certified by USDA, AMS, the purchaser MUST specify that option in the contract or purchase order. When the purchaser requests that the fat content to be certified by USDA, an average sample shall be drawn by the AMS agent and sent to the USDA, AMS laboratory for fat analysis.

ORDERING DATA: OPTIONS AND FORMULA DESIRED SHALL BE SPECIFIED BY THE PURCHASER

COOKING OPTION

- B - Cooked
- C - Uncooked



Item No. 825 - Canned Luncheon Meat

Carcass pork and/or beef shall be the only meat ingredients used and shall be chopped or ground slightly coarse to moderately coarse in texture. The finished product shall have good cohesion and hold together as an intact unit when removed from the can. The product, depending on the formulation, shall have a uniform color, ranging from pink to reddish-brown. (Slight variation between internal and external surfaces is permitted). Fat shall not cover more than 10 percent of the outer core surface. Hearts, tongues, and other variety meat items shall not be allowed. Other ingredients (salt, curing ingredients, sweetening agents, spices, flavorings, etc.), shall be as allowed under MPIO Regulations.

The filled cans shall be vacuum sealed, and thermally processed.

Unless otherwise specified, the fat content of the product shall not exceed 25.00 percent. The purchaser may specify discount ranges in the procurement data. Unless otherwise specified, the salt content of the product shall be not more than 1.50 percent.

End Item Examination - Product having an internal temperature of 50°F to 80°F (10°C to 26.7°C) shall be randomly selected for an end item examination. For examination, each sample core shall be removed from the can intact and examined in accordance with the Quality Assurance Provisions Table 800D. The sample core shall be divided into four (4) approximately equal pieces by three (3) straight cuts perpendicular to the cutting table surface and at an approximate right angle to the core length. The three right hand cut surfaces shall be evaluated for all applicable defects listed in the IMPS Quality Assurance Provisions. If specified by the purchaser, a net weight examination of the filled cans shall be performed. For detailed sampling procedures see the IMPS Quality Assurance Provisions.

All cans of product within each lot shall bear identical can code markings to make them distinguishable from cans of product in other lots.

Cans. Cans shall be commercially acceptable, open-top style, coated with enamel (or other suitable material) inside and outside, and hermetically sealed. One of the following can sizes shall be specified by the purchaser:

A. 30 ounce (850 g) net weight

<u>Size</u>	<u>Shape</u>
400 x 411	Cylindrical
404 x 404	Cylindrical

B. 6-pound (2.72 kg) net weight

<u>Size</u>	<u>Shape</u>
400 x 400 x 1110	Rectangular
402 x 314 x 1200	Rectangular
402 x 310 x 1204 to 1210	Rectangular

Item No. 826 - Scrapple

Scrapple is prepared from meats (either pork or beef as specified by the purchaser) and meat by-products, with conventional flavorings/spices and a flour and broth base.

Scrapple shall not contain ears, lungs, udders, kidneys, spleens, brains, tongue, cracklings, or cured product. The finished product shall be molded and packaged into a rectangular shape (unless otherwise specified) and shall be moderately firm and stable to permit customary slicing. The interior cut surface shall be smooth and fine-textured with light to dark flecks and pieces evenly distributed across a moderate to dark grayish-pink background.

ORDERING DATA: OPTIONS AND FORMULA DESIRED SHALL BE SPECIFIED BY THE PURCHASER

Formula (major ingredients only)

- A - Pork
- B - Pork and beef
- C - Beef

IV. GLOSSARY OF TERMS FOUND IN THIS SPECIFICATION

BEEF HEART MEAT - Allowable only when the formula selected by the purchaser specifically authorizes its use. Must be listed separately in the ingredient statement.

CASING (COLLAGEN) - Collagen casings are edible; however, collagen casings are not considered "natural."

LABELING TERMINOLOGY IDENTIFIED IN THIS SPECIFICATION

A. **BEEF** - When a single meat species is listed within the ingredient statement, this shall be the ONLY meat ingredient allowed.

B. **BEEF AND PORK** - When labeled as beef **AND** pork or pork **AND** beef, the percentage of the two individual species may be in any combination and may be interchanged without a change being made to the ingredient statement however, neither of the species listed shall be less than 30 percent of the total meat portion.

C. **BEEF, PORK** - When listed as **beef, pork** or **pork, beef** the percentage of the two individual species may be in any combination, however the first species listed shall be the predominant species of the total meat component.

D. **BEEF AND TURKEY or PORK AND CHICKEN** - Sausage items which have been manufactured using a combination livestock and poultry formula, in which the livestock portion is over 50 percent and the poultry portion exceeds 15 percent of the formula, shall be labeled as the livestock portion **AND** poultry portion respectively. EXAMPLE: BEEF AND CHICKEN FRANKFURTER, etc.

Sausage items which have been manufactured using a combination livestock and poultry formula, in which the poultry portion is less than 15 percent of the formula, shall be labeled as the livestock portion **WITH** poultry portion **ADDED** respectively. EXAMPLE: BEEF FRANKFURTER WITH CHICKEN ADDED

MEAT COMPONENTS - Unless otherwise specified, whenever the terms beef, pork, veal are used, they indicate the use of skeletal muscle tissue from the species identified. Non-skeletal meat ingredients (when authorized) shall be individually identified in the ingredient statement.

PIMENTO - The dried berries of *Pimenta officinalis*, a tropical American tree.

PIMIENTO - The red fruit of the Spanish sweet pepper.

MOTTLED - The cut surface area shows a distribution of light to dark colored flecks on a uniformly colored background.